

Date: Wednesday, 12/7/2005 8:26:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 25141	
Estimate Number : 11001	
P.O. Number : N/A	Part Number : D26022
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D2602 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/10/2006 Qty: 10 Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total: 14.1456 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch M19059

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut Blank per template DT8243

J.L 05-12-16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA145 and Dwg D2602
 Stack of 10
 Identify as D2602-2

J.L 05-12-16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05-12-16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 05-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D26022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 06/01/16 10

SAD 12/18/05 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-16

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-01-20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 06-01-24

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/01/24 10

10 06/01/24 10

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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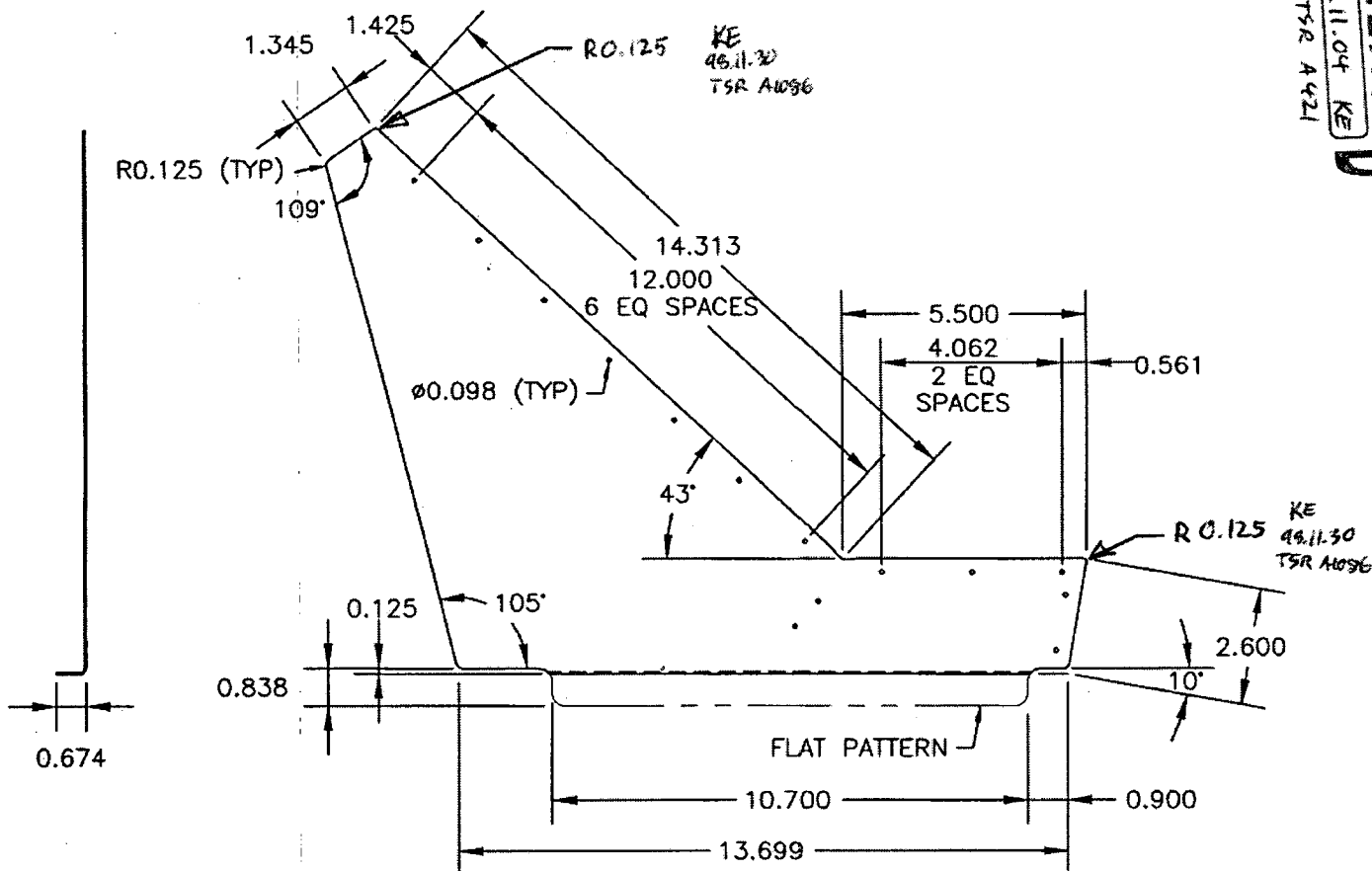
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED <i>KE</i>	APPROVED <i>Bu</i>	DRAWING NO.	REV. A	
DATE 97.10.22		D2602	SHEET 1 OF 1	
		TITLE CONSOLE SIDE	SCALE 1:4	
A	97.10.22	D2602 WAS D206-547-21/ -22		
AI	02.06.04	ADD FINISH		

RELEASED
97.11.04 KE
TSR A421



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1 Δ AI
D2602-1 SHOWN
D2602-2 OPPOSITE

DESIGNED BY
ENGINEERING
DART AEROSPACE LTD
VICTORIA INTERNATIONAL AIRPORT
CANADA

25141